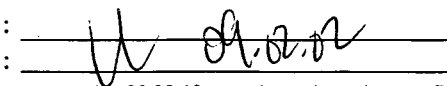


Date: Wednesday, 18/02/2009 2:52:52 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SIDE DOOR
Job Number :	45403		
Estimate Number :	12295		
P.O. Number :		Part Number :	D350589041
This Issue :	18/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2991 REV.C
First Issue :	02/02/2009	Project Number :	N/A
Previous Run :	42908	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :		Due Date :	20/02/2009
Comment :	est rev. A 06.02.16 new issue (was done on D350-589-041) EC Est Rev:B 08-02-20 ECN 1096 DD verified by:EC est rev C 08.06.26 Revised pik list per QC comment (w/o 25885) EC verified: DD		



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



JD 09.05.20



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-041

CHG003

S 09165100
CHG 004 PRO

2.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8112 C209102/03

Description: D2991-1 side door

Supplier: Delastek

batch:

Ship to delastek: Qty 2 (D2992-1) Doubler

B3138743 C209102/03 (2)
B4667 C209102/03 (2)

Ensure batch # on Label D3721-1 match W/O # for D350-589-041

Certificate of Conformity and process sheet from Delastek is required

B46789 C209104/15 (2)

3.0	D29921	Doubler
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Doubler

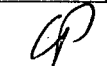
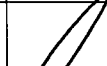
C209102/03 (2)

4.0	D29911	Side Door
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Side Door

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
04.04.27	1	1) 2492-1 NOW WIDER KIT NOW @ CHG 604				 09.05.20 PC 031042	 16/05/20	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:52:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45403

Part Number: D350589041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

**ENGINEERING
APPROVAL**

6/5/14 (1) 09.05.20

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

6/5/19 (1)

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description
1	D2464-1700	Foam seal

Batch

B39669

9/1/20

090520

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2585	Latch clamp

Batch

B45815

9/6/20

54

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2586	Door latch

Batch

B45554

9/5/20

50

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2621	latch plate

Batch

B41175

9/5/20

50

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:52:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45403

Part Number: D350589041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

11.0	D3085041	prop ass'y
------	----------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3085-041	prop ass'y

Batch

B45557

9/5/20

50

12.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description
6	MS21042L3	Nut

Batch

M110894

9/5/20

50

13.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	AN960JD10	Washer

Batch

M111279

9/5/20

50

14.0	MS27039115	Screw
------	------------	-------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	MS27039-1-15	Screw

Batch

M110915

9/5/20

50

15.0	D37211	Decal
------	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch:

B45472

9/5/20

50

16.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
------	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

CJ 09 05 19

16.1 TRIM to 350 cut open slots for latches

AA 090520

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:52:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45403

Part Number: D350589041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20905-20

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick list:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch:

B45526

SS 09/05/20 (X)

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch:

B45585

SS 09/05/20 (X)

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

3

D2237

Striker Plate

43938

SS 09/05/20 (X)

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1

D2589

keys, key chain

B38814

SS 09/05/20 (X)

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

AN3-4A

Bolt

M103641

SS 09/05/20 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:52:52 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45403

Part Number: D350589041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

24.0	MS20470AD45	Rivet, Universal Head
------	-------------	-----------------------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
6	MS20470AD4-5	Rivet	M109031

SS 09/05/20 (XU)

25.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Nut

M110844

SS 09/05/20 (XU)

26.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/05/20 (XU)

27.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rev E

SS 09/05/20 (XU)

28.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

SS 09/05/20 (XU)

Job Completion



MF 09-05-20

POSITIVE RECALL

EFFECTIVE UP AUTH 05.04.27

RELEASED UP DATE 05.05.20

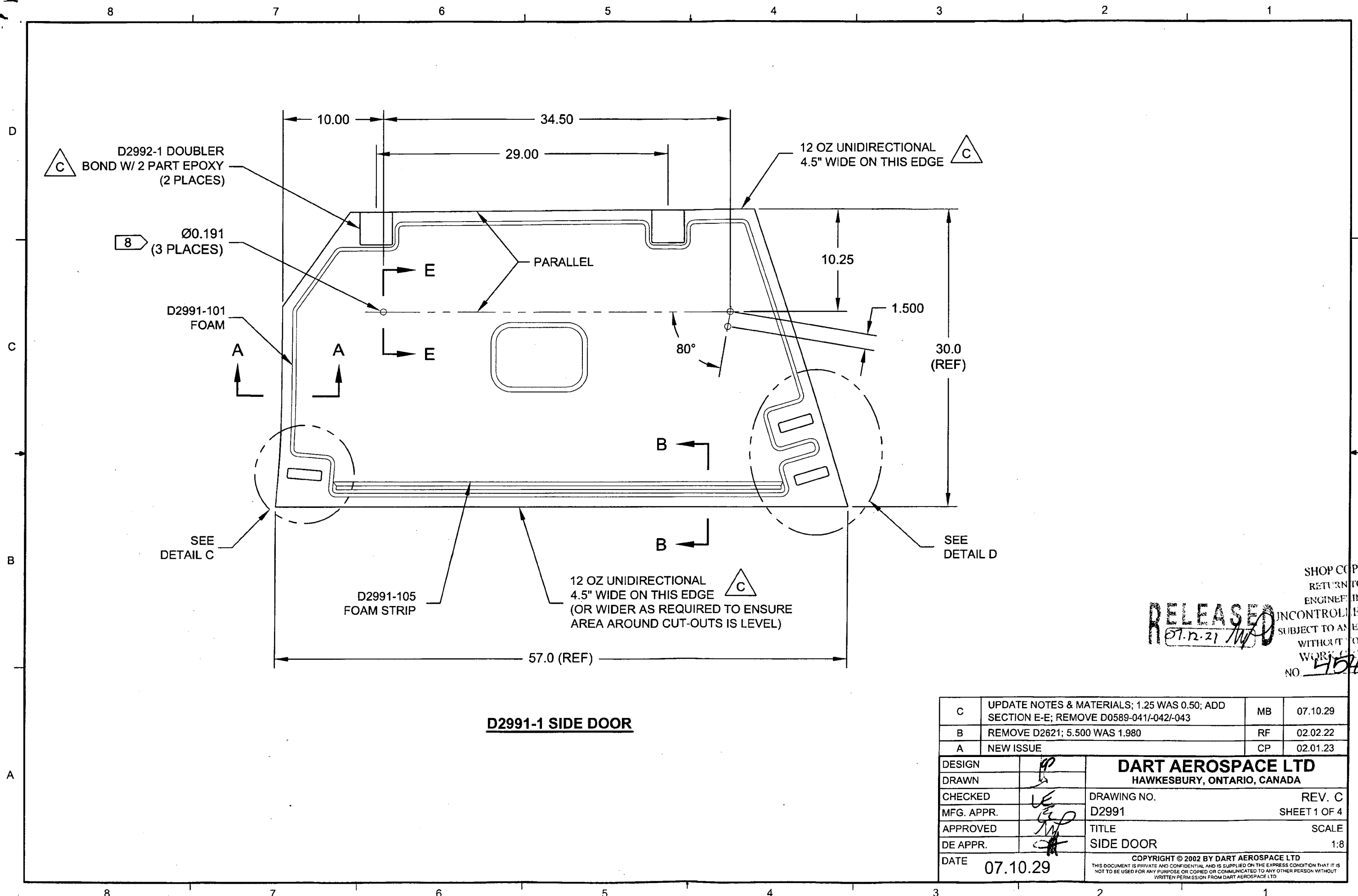
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

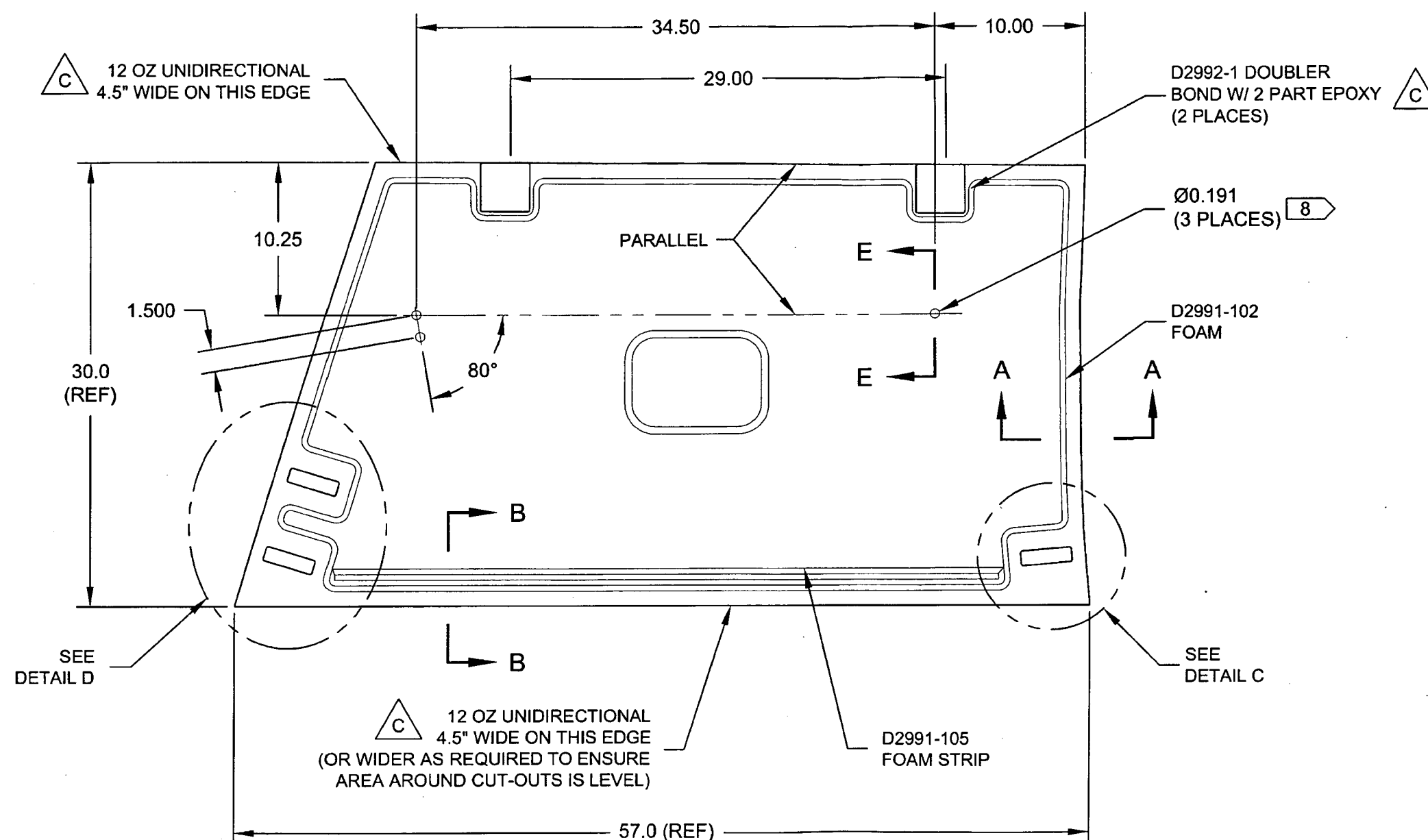
NOTE: Date & initial all entries



D2991-1 SIDE DOOR

C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			
CHECKED	DRAWING NO.		REV. C
MFG. APPR.	D2991		SHEET 1 OF 4
APPROVED	TITLE		SCALE
DE APPR.	SIDE DOOR		1:8
DATE	07.10.29	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

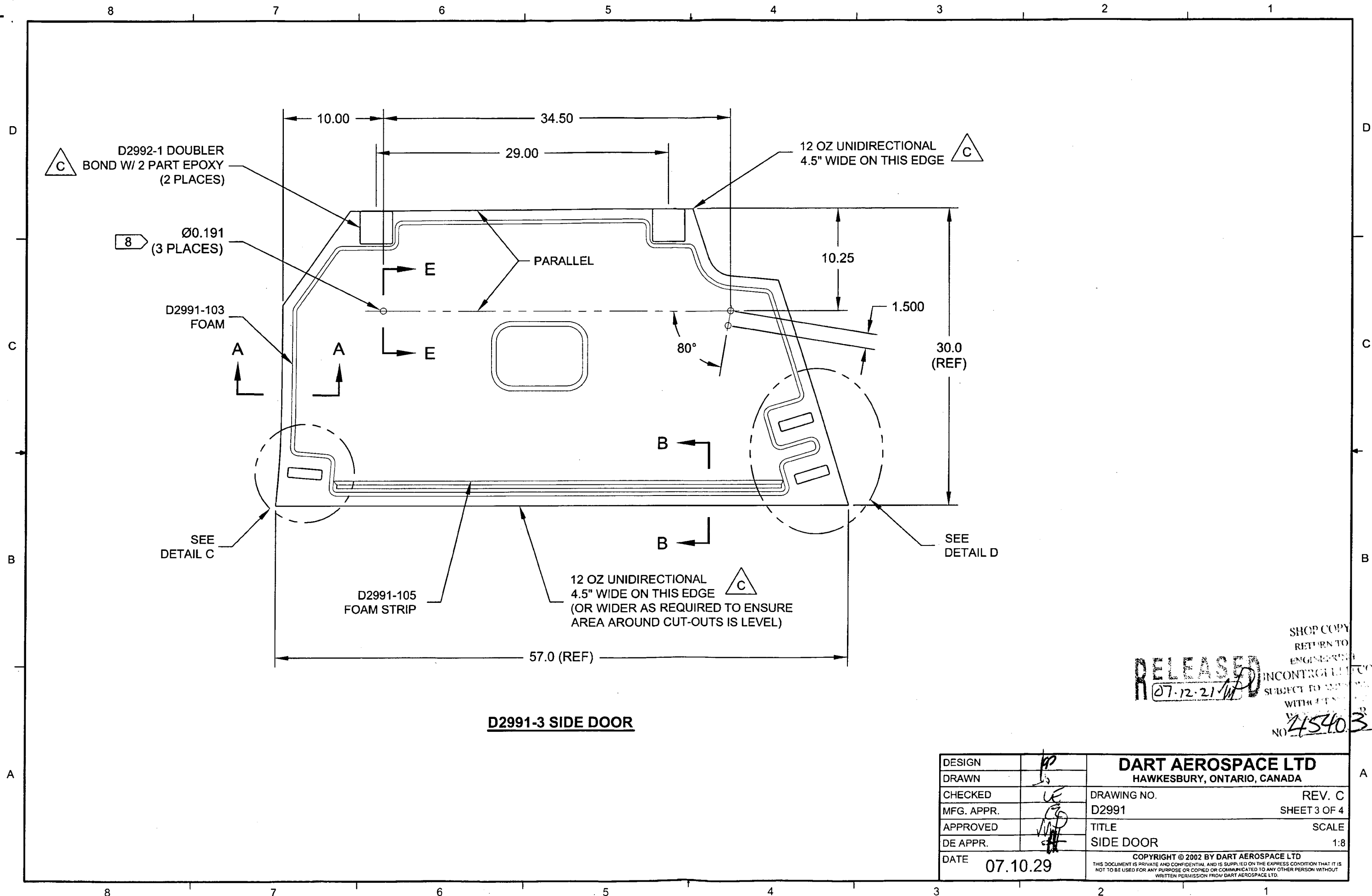
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07.12.21
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. **45403**

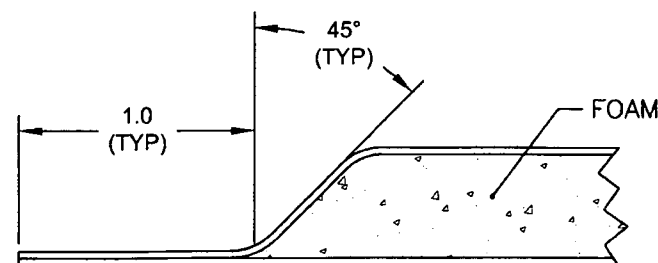


D2991-2 SIDE DOOR

SHOP COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AGREEMENT
 WITHOUT NOTICE
 WORK ORDER NO. 45403

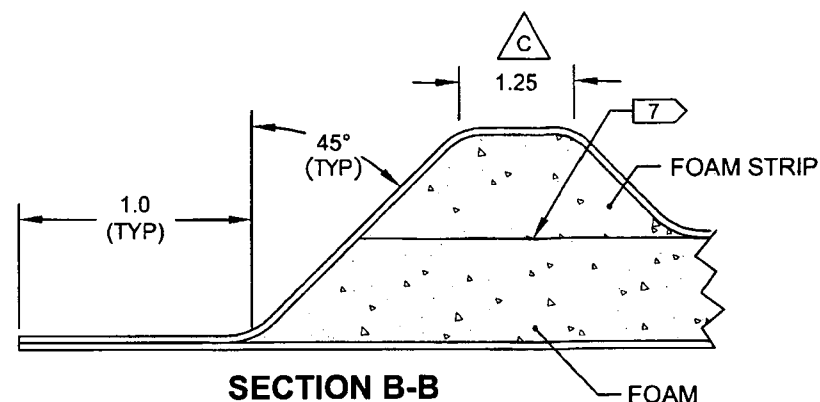
DESIGN	BP	DART AEROSPACE LTD	
DRAWN	LS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UC	DRAWING NO.	REV. C
MFG. APPR.	GP	D2991	SHEET 2 OF 4
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





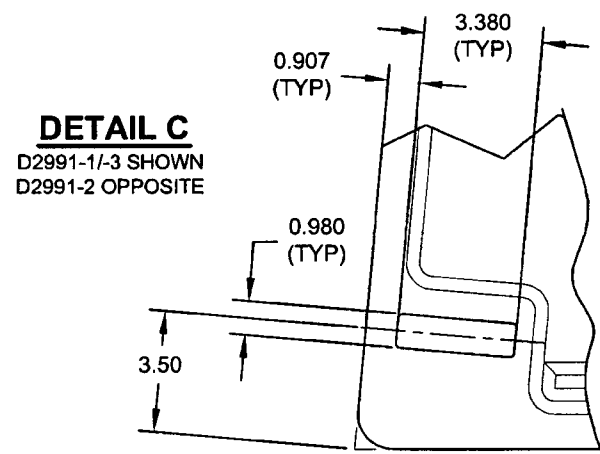
SECTION A-A

NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



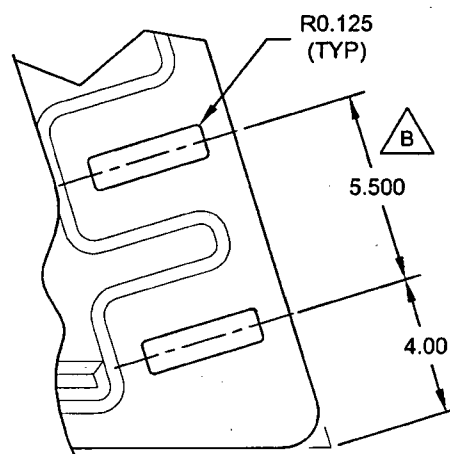
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



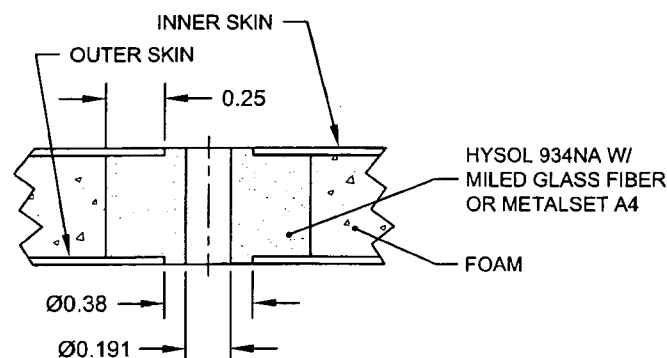
DETAIL C

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/-2/-3



- LAYUP PER QSI 006 AND AS FOLLOWS
- MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- BOND FOAM CORE USING POLYBOND B46F
- DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- WEIGHT: 9 lbs (TYP)

RELEASED
67-12-21 WDD

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SUBJECT TO ANY
WITHOUT NOTICE
NO. 45103

DESIGN	PP	DART AEROSPACE LTD	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. C
MFG. APPR.	CE	D2991	SHEET 4 OF 4
APPROVED	CE	TITLE	SCALE
DE APPR.	CE	SIDE DOOR	1:
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13158
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
13/05/2009	03/02/2009	5973	Chantal Lavoie		PO00008112		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B45403 Dwg.: D2991 Rév.: C annoté Job: 43778 U de M : Each			
1	0	1	DKC134-0051	Side Door N° D2991-2 B45406 Dwg.: D2991 Rév.: C annoté Job: 43780 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Jeudi, 2009-04-23 08:40:39
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : SIDE DOOR N° D2991-1	G.
Numéro Job : 43778		Numéro Article : DKC134-0000	-0050
Numéro Soumission : 2642		Numéro Dessin : D2991	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2009-04-23	No. B.V. :	Révision dessin : <i>E C ANNOTÉE</i>	
Prsht Rev. : NC		Matériel : Composites	
Prem. fois : - -	Type :	Date Dûe : 2009-04-30	Qté: 1 Udm: UNITE
Job précédente : 43698			
Écrit par :			
Vérifié & Approuvé par :			
Commentaires :	N° de pièce Client: D2991-1		

Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0582 Frekote 700NC N° 38425


Commentair Qty.: 0.025 GALLON(s)/Unit Total: 0.025 GALLON(s)

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation du moule N° DKO-0094 laisser sécher pendant 3 heures selon le QSI-006 et IG 0009.

Date: 22-4-09 Sceau: 

3.0 AAC0273 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total: 1.000 KILOGRAMME(s)

4.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0250 UNITE(s)/Unit Total: 0.0250 UNITE(s)

5.0 AAC0198 UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total: 0.014 GALLON(s)

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 5% de UN2055 styrene monomere ST

Date: 23-4-09 Sceau:  Temps Début: 8:15 Temps Fin: 8:30

Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43778

Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 GEL COAT. APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du gel coat sur le moule N° DKO-0094 selon IG 0019

Date: 23-4-09 Sceau:



8.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0 AC0407 Wrighton 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0 AC0752 Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0 AAC0276 Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s) 1-7012-1

13.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s) 1-21929-1

14.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s) ✓

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 15-4-09 Sceau:



Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43778Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
16.0	AAC0274	Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s) 1-24094-1

17.0 AAC0275 " Catalyst N° DDM-9

Commentair Qty.: 0.0060 UNITE(s)/Unit Total : 0.0060 UNITE(s) 1-22176-1 ✓

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 23-4-09 Heure Début: 12:30 Heure Fin: 12:35 Sceau:



19.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0094 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 23-4-09 Heure Début: 12:35 Heure Fin: 12:50 Sceau:



20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Date: 23-4-09 Sceau:



Curing début: 12:35 Curing Fin: 9:15

21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.143 KIT(s) 1-6724-1

22.0 DKC134-0062 Foam Core N° D2991-101 (Porte D2991-1) 43654

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) ✓

Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43778

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Retirez le bagging.

Installer le Foam Core selon IG 0033

Date: 24-4-09 Heure Début: 10:40 Heure Fin: 10:55 Sceau:



24.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire la poche à vide selon IG0012

Laisser sécher pendant 2 heures minimum.

Date: 24-4-09 Sceau:



Curing Début: 10:40 Curing Fin: 11:55

25.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)

1-24094-1

26.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0040 UNITE(s)/Unit Total: 0.0040 UNITE(s)

1-22176-1

27.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1-5-09 Heure Début: 10:15 Heure Fin: 10:20 Sceau:



28.0 LAMINAGE. LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43778

Numéro Article: DKC134-0066

Numéro Job:



Séq.: Machine ou Opération: Description :

Faire le laminage du dernier pli de 9.7 oz.

Date: 1-5-09 Heure Début: 10:20 Heure Fin: 11:25 Sceau:



29.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 1-5-09 Heure Début: 11:25 Heure Fin: 11:35 Sceau:



Curing Début: 10:20 Curing Fin: 8:00

30.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 4-5-09 Sceau:



31.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

À l'aide du gabarit N° DKO-0118 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 4-5-09 Sceau:



32.0

AAC0433

Hysol 934NA part A&B (quart kit)

1-22083-1

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)

33.0

AAC0673

Fibre de verre Miapoxy 66

1-6872-1

Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s)

Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43778

Nom Dessin: SIDE DOOR N° D2991-1
Numéro Article: DKC134-0066

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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34.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0118 Percer les 3 trous de 1/4" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préallablement fait dans le foam Core.

Laisser sécher.

Date: 5-5-09 Sceau:



35.0	TRIMAGE	TRIMAGE DE FINITION
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKO-0118 Repercer les 3 trous de 1/4" Dia.

Date: 6-5-09 Sceau:



36.0	AAC0433	Hysol 934NA part A&B (quart kit)
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Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

37.0	AAC0697	N° D2992-1, Doubler
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Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

38.0	ASSEMBLAGE	ASSEMBLAGE GÉNÉRALE DES PIECES
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 5 mai 09 Sceau:



Date: Jeudi, 2009-04-23 08:40:40

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SIDE DOOR N° D2991-1

Numéro Job: 43778

Numéro Article: DKC134-0066

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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39.0	AAC0683	Dupont Primer N° 7704S
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Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

1-22968-1

40.0	AAC0685	Dupont Activator - Reducer Chromabase N° 7775S
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Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)

1-23133-2

41.0	PRIMER	APPLICATION DE PRIMER
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Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

08/05/09



Date: 07/05/09 Sceau:



42.0	INSPECTION 3	INSPECTION PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection selon le dessin N° D2991

Date: 13-5-09 Heure Début: 11h15 Heure Fin: 11h30 Sceau:



43.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'emballage des pièces.

Quantité: 1 Date: 13-5-09 Sceau:



